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(71)Applicant : SHOWA DENKO KK
SHIYOUTEITSUKU:KK

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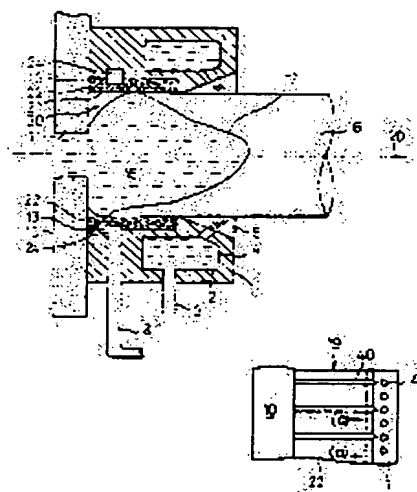
(72)Inventor : YANAGIMOTO SHIGERU
YOKOI KATSUMI
SUZUKI KENJI
TAKAHASHI YASUHIRO

(54) METHOD AND APPARATUS FOR HORIZONTALLY CONTINUOUS-CASTING METAL

(57)Abstract:

PURPOSE: To stabilize quality of a casting billet and to improve yield on product by continuously making seep of lubricating fluid on inner wall face of cylindrical mold at the time of continuous casting and discharging the lubricating fluid and generated gas to the end part of the mold through grooves formed at inner face of the mold.

CONSTITUTION: The permeable porous mold 22 is arranged at inner wall corner part of the cylindrical mold 1 and an annular passage 24 and an oil supplying pipe 8 are arranged. Plural grooves 40 are formed on a part of inner face 21 in the mold 22 covered from jointing face with refractory plate-like body 10 to end part of the cylindrical mold 1. The lubricating oil supplied from the oil supplying pipe 8 under pressurizing is made to seep to the inner face 21 of the porous mold, and the inner face 2 of the mold, outer peripheral face of columnar molten metal body and outer peripheral face of non-solidified metal body are lubricated. Further, a part of the lubricating fluid and gas of decomposited gas as main part are discharged to the end part of the mold from space 30 at the corner part from grooves 40. By this method, the lubrication at each part is automatically uniformized and the quality of the cast billet is stabilized. Therefore, the yield of the product is improved.



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